

Work Order ID 144905

April 27, 2016 11:27:01 AM

~~U/R~~

144905

Special Instructions
for Bell

Page 1

Item ID: D3594-043

Revision ID: URF 16-531

Item Name: Floor Doubler Assembly, LH

Start Date: 4/28/2016 Start Qty: 4.00

Required Date: 5/10/2016 Req'd Qty: 4.00

Reference:



4

4

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer: CBELL02

Approvals:

Process Plan: SLTDate: 4/28/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3594

Rev B U/R

OK 4/16/17

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.40

FLOW CNC Waterjet

1-Cut as per Dwg D3594

Dwg Rev: BProg Rev: B

2-Deburr if necessary

★
PRO

(5)

DC 4/10/05/04

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control

(5)

DC 4/10/05/04

DQA:

Date: 16.05.27



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~16/05/17~~

Date: 16/05/17

Work Order update only



Work Order: <u>144905</u> Part No. <u>D3594-043</u> NCR No. <u>16-5786</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Cut doubler per marked up dwg. Customer request.		Acceptable to cut doubler Lth enlarged dimensions. Required to maintain proper edge distance when installing gas spring		Completed By DAS 12 9-89 <u>16/4/27</u> Lead hand / Supervisor Approval Verification DAS 38 MAY 05 2016 QC / QA Coordinator Approval DAS 38 MAY 05 2016																																																																
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 144905

April 27, 2016 11:27:01 AM

144905

Page 3

Item ID: D3594-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-531 Stop ***NS2***
Item Name: Floor Doubler Assembly, LH
Start Date: 4/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/10/2016 Req'd Qty: 4.00 ***4*** Customer: CBELL02
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.20							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.04							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.12							
Small Fab	Install Nut Plates As per Dwg D3594								

5 * 4 16/05/05

(5) 38 9-89 MAY 06 2016

5 FF MAY 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Revision ID: URF 16-531 Stop ***NS2***
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Start Date: 4/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/10/2016 Req'd Qty: 4.00 ***4*** Customer: CBELL02
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									DAS
QC	Memo	0.08							38
Quality Control									9-89
									MAY 06 2016
190	Identify as per dwg & Stock Location: <u>Quarantine</u>	0.00							
190									
Packaging	Memo	0.04							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.40							
Quality Control									



POSITIVE RECALL

EFFECTIVE _____

RELEASED _____

MLJ

DATE

MAY 10 2016

④ ship to bell

① quarantine

PD 1605-01

MLJ

MAY 10 2016

Signature 160509

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

April 27, 2016 11:27:05 AM

Page 1

Work Order ID: 144905

144905

Parent Item: D3594-043

D3594-043

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD4-4		Purchased		No		100	Each	4,755.000	2	8			

MS20426AD4-4

Rivet

**

FF

MAY 06 2016

Location

Loc Qty

Loc Code

GA

2078

125445

2078

810

ST312

2677

m132536

2677

M6061T6S.080

Purchased

No

170

sf

160.3000

0.51

2.147368

M6061T6S 080

6061-T6 .080 Sheet

**

De 16/05/04

Location

Loc Qty

Loc Code

MAT020

160.3

134217

32

m132772

5.3

m133587

40.2

m133828

18.8

m134551

64

2.4.4

MS21069-5

Purchased

No

170

Each

84.0000

1

4

MS21069-5

Anchor nuts

**

FF

MAY 06 2016

Location

Loc Qty

Loc Code

ST299

84

m131920

84

5

Under Review Notification

Raised By: M. BELLAVANCE

Product #: D412-698-023

Date: 16.02.25

Product Name: AUTOMATIC DOOR OPENER KIT

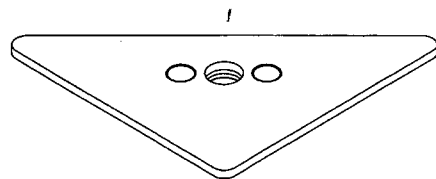
Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3594-043/-044/-3/-4	D3594 Rev. B	N	Y	N	Y	N	Y	N	16-531	See below.
D412-698-023	IIN-D412-698 Rev. E	N	Y	N	Y	N	Y	N	16-531	See below.

Description of Issue:

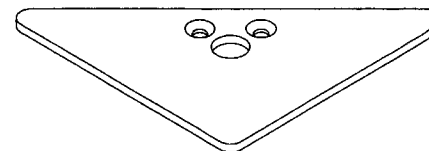
Current stock OK to ship to customers other than Bell Helicopter Mirabel.

If shipping to Bell Helicopter Mirabel: must ship D412-698-023 with enlarged D3594-043/-044/-3/-4. Eng. To sign off deviations on W/Os.

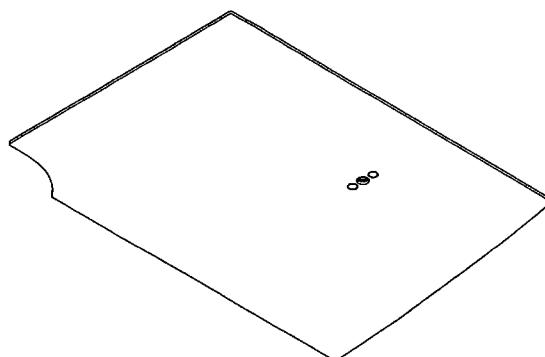
Change: addition of material, 0.25", on the inboard and outboard edges as shown to facilitate installation with existing equipment.



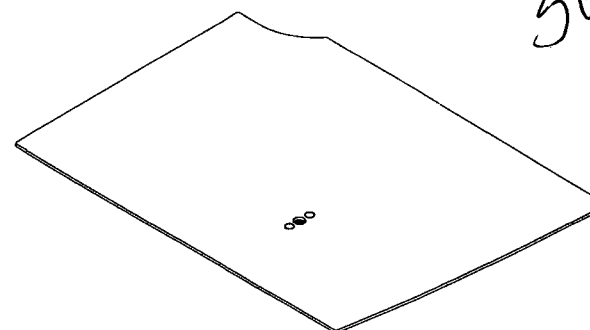
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

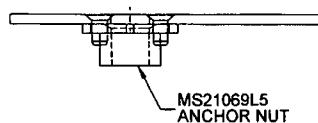
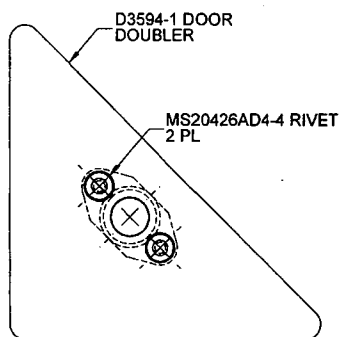
20180427

SH 144905

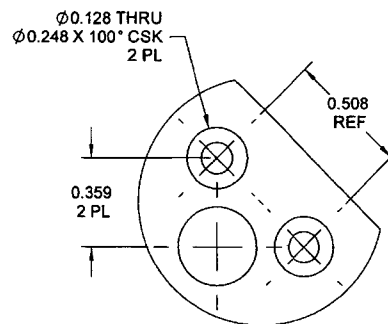
RELEASED
08052614

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

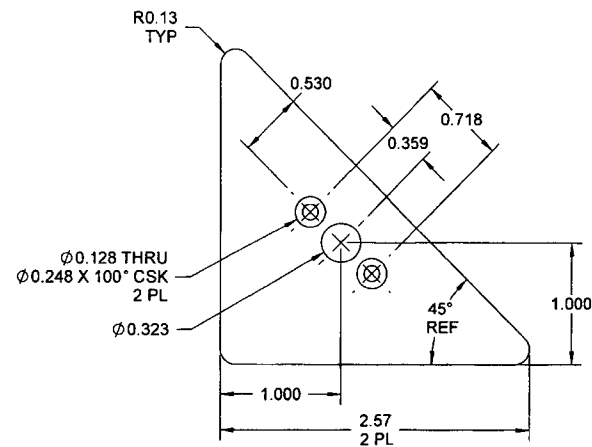
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



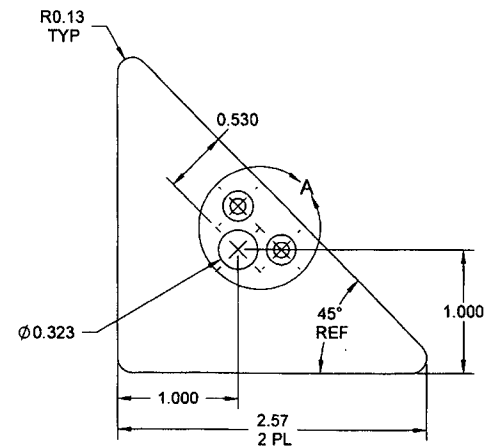
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER B

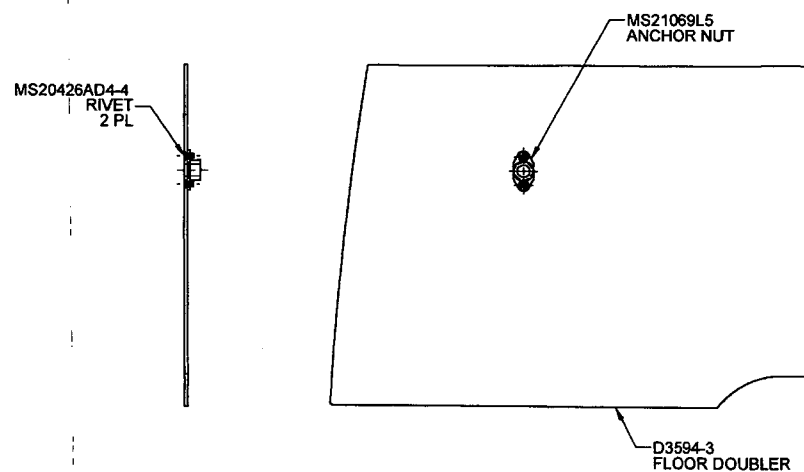
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

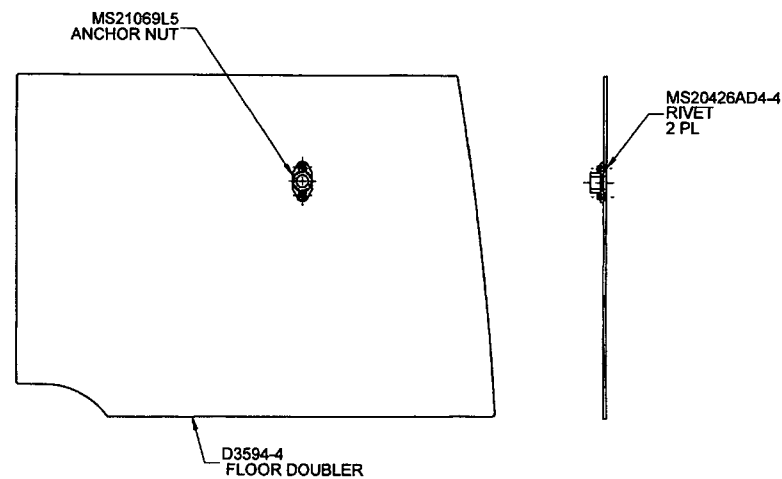
RELEASED
08-06-26-14

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



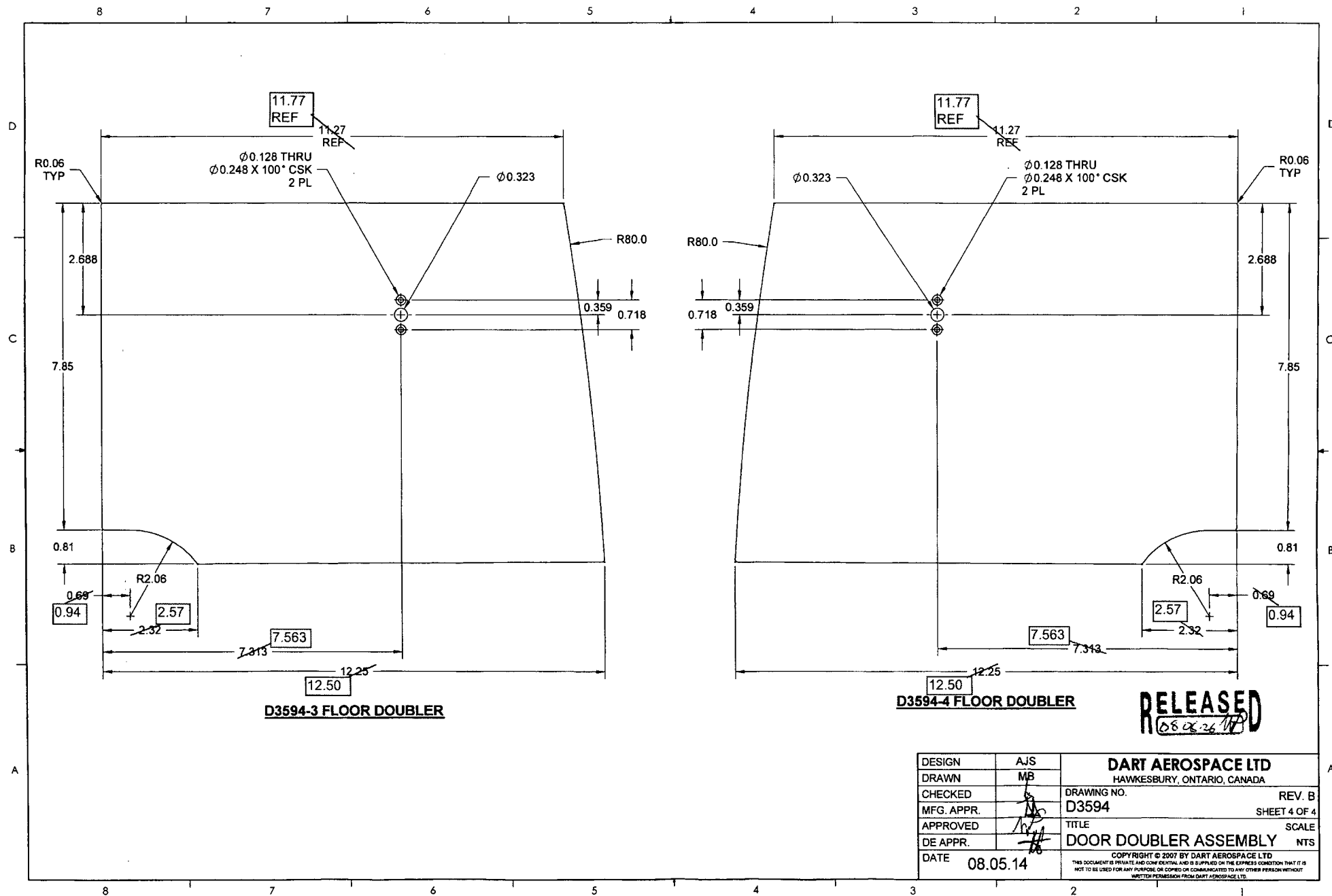
D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
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RELEASED
08-06-2014



Beer Order

DART AEROSPACE LTD	Work Order:	144905
Description: Floor Doublwr Assembly LH	Part Number:	3594-043
Inspection Dwg: 3594 Rev: B		Page 1 of 1

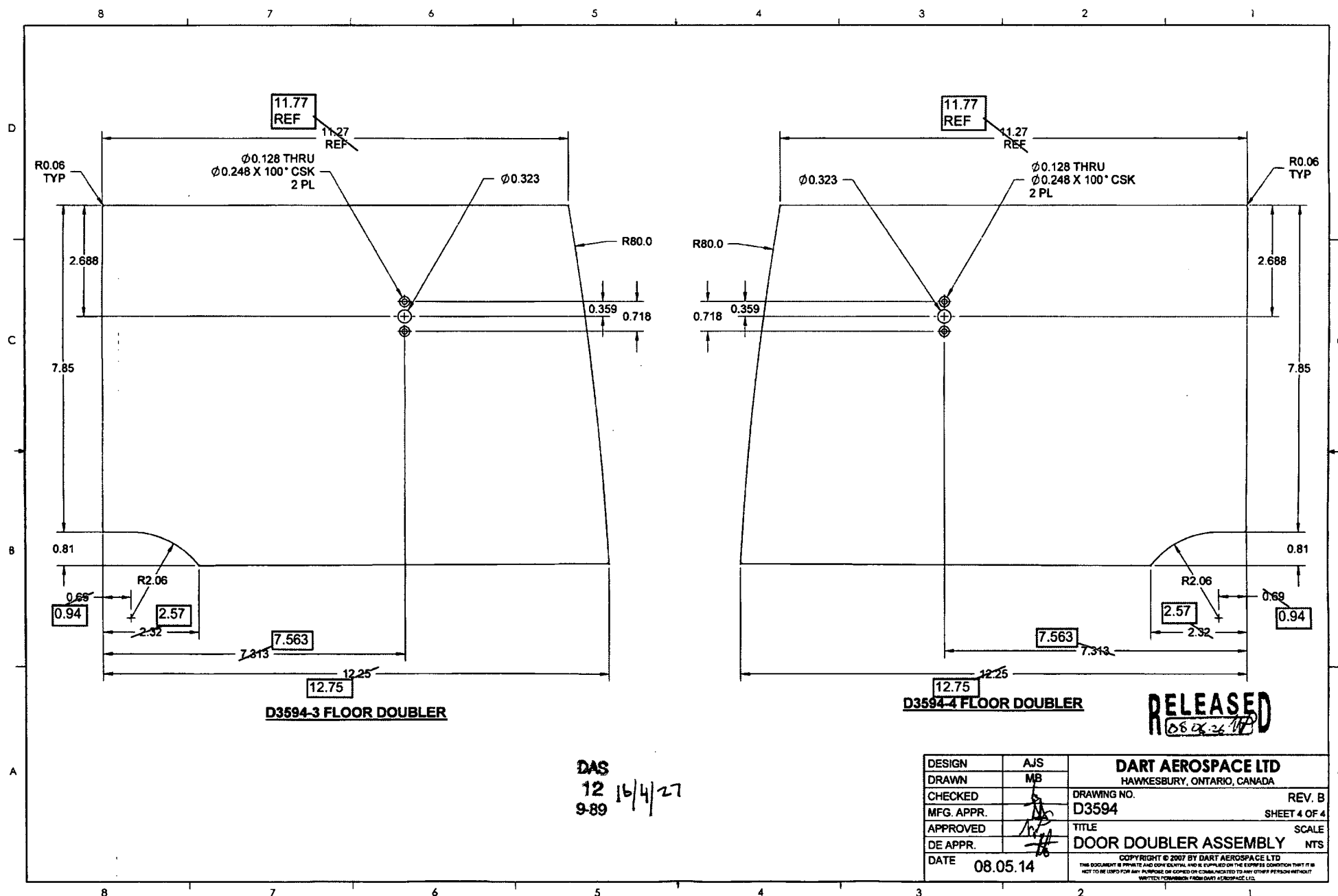
INSPECTION SHEET

[illegible]

Measured by:	DC	Checked by:	38	QC Inspector:	
Date:	16/05/09	Date:	9-89 MAY 05 2016	Date:	

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



DAS
12 16/4/27
9-89

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR DOUBLER ASSEMBLY	NTS
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